

WELDING CHARACTERISTICS:

Current: AC and AC **Tungsten Type:** EWTh-2 **Transfer Mode:** N/A
Ranges: Amps 25 to 300 **Tungsten Dia.:** 3/32 **Pulsing Cycle:** 40 to 60
Volts 12 to 22 **Background Current:** 0
Fuel Gas: N/A **Flame:** N/A **Braze temp. °F** 0 to 0

WELDING TECHNIQUE: For fabrication specific requirements such as fittup, cleaning, grinding, PWHT and inspection criteria refer to Volume 2, Welding Fabrication Procedures

Technique: Manual **Cleaning Method:** Wire Brush, File, Grind
Single Pass or Multi Pass: M **Stringer or Weave bead (S/W):** S/W **Oscillation:** N
GMAW Gun Angle °: 0 to 0 **Forehand or Backhand for GMAW (F/B):** N/A
No Pass S>1/2": **GMAW/FCAW Tube to work distance:** N/A
Maximum K/J Heat Input: 0 **Travel speed:** Variable **Gas Cup Size:** # 5

PROCEDURE QUALIFIED FOR:

Charpy "V" Notch: N/A **Nil-Ductil Transition Temperature:** N/A **Dynamic Tear:** N/A

Comments:

Weld Layer	Manual Process	Filler Metals	Size	Amp Range	Volt Range	Travel/ipm	Nozzle Angle	Other
1	GTAW-	ER4043	1/16	25 to 160	12 to	to	0 to 0	
2	GTAW-	ER4043	3/32	150 to 250	to	to		
3	GTAW-	ER4043	1/8	240 to 300	to	to		
4	GTAW-	ER4043		to	to	to		
5	GTAW-	ER4043						
6								

REM. * Weld layers are representative only - actual number of passes and layer sequence may vary due to variations in joint design, thickness and fitup.

Use of LANL Welding Procedures and Welder Qualifications for non-LANL work shall be at the sole risk and responsibility of the Subcontractor, and the Subcontractor shall indemnify and save LANL and the Government harmless from any and all claims, demands, actions or causes of action, and for any expense or loss by reason of Subcontractor's and their employees possession and use of LANL procedures and qualifications.